Stop St	Work Ord		3076									Pag
Start Date: 4/22/10 Start Qty: 2.00 Cust Item ID: Required Date: 4/30/10 Req'd Qty: 7.00 Customer: Reference: Approvals: Process Plan: Date: Date: Date: Date: Stop Date: Stop Date: Stop Date:	Revision ID:		Ų.0	GM	Accept							
QC: Date: SPC (Y/N): Draw Draw Plan Accept Reject Reject In Run Hours Number Rev. Code Qty Qty Number S Draw Nbr Revision Nbr B	Required Date:						D:					
Work Center ID Description Run Hours Number Rev. Code Qty Qty Number S Draw Nbr Revision Nbr D4049 B 100 0.00	Approvals:		an:f		•				j			
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(4000) (00) (00) (00)			vision Nbr		,			·				
Bandsaw Memo 0.00 /3 /1 /0/04/29 Jeaspa Bandsaw CUT BLANK 2.200" LONG	Bandsaw			IK 2.200" LONG	. 1	10/04/29			4	Ø		

110

HAAS I

HAAS CNC vertical machine #1

Memo

mill as per dwg and FOLIO FA900 FOLIO REV: ______ DWG REV: _____





DEBURR

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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	\ :	Date:	
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Work Order ID 58076

April 22, 2010 2:24:49 PM



Page 2

Item ID:

D4049-2

Accept



Setup Start



Revision ID:

Start Date:

Item Name: Lug

Required Date: 4/30/10

4/22/10

Start Qty: 2.00

Req'd Qty: 2.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Date: Date:

Draw

Stop

Start

Stop



Sequence ID/ **Work Center ID**

120

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours**

Draw

Number

Rev. Code

Plan

Accept Reject Qty Qty

Run

Reject Number Stamp

Insp.

Quality Control

Memo

130

Quality Control

QC8- Inspect parts - second check

Memo

0.00

140

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Q 10-5-3



W/O:			W	ORK ORDER CHANG	ES					7 1	
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Work Order ID 58076



Page 3

April 22, 2010 2:24:50 PM

Item ID:

D4049-2

Accept



Setup Start

Stop



Revision ID:

Item Name: Lug

Start Date: 4/22/10

Required Date: 4/30/10

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID: Customer:

Reference:

Approvals:	
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Process Plan:

Date: _____

Tooling:

Date:

Start



QC:

Date:_____

SPC (Y/N):

Date:

Plan

Code

Stop



Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

Draw Number

Draw Rev.

Accept Qty

Reject Qty

Insp. Number Stamp

0.00

Run

Reject

	•									
W/O:			W	ORK ORDER CHANG	iES					7
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Part No: PAR #:			Fault Cat	egory:	_ NCR: Ye	es N	o DQ	\:	_ Date: _	
	Resolution: Disposition:				QA: N/C	Clos	ed:		Date: _	
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Picklist Print

April 22, 2010 2:24:48 PM

Work Order ID: 58076

D4049-2 Parent Item:

Parent Item Name: Lug

IPP REV: A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

as per dwg revA DD 10.02.18 verified by:EC

IPP Rev:B

Start Date: 4/22/10

Qty

Issued

Required Date: 4/30/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch Purchased

Primary Item Location

No

Last Route Location Seq ID 100

Unit of Qty on Measure Hand 26.8000

Remaining Qty To Pick 0.3160

Date Issued

Status

Page 1

M304B0.500X1.500

Comments:

304 BAR .500 x 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53

113762

26.8

26.8

0.6320 ff H.A 10/04/29

Dart Aerospace L	Lta
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W/O:			WC	RK ORDER CHANG	GES					, ,
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58076

DART AEROSPACE LTD	Work Order: \$8074
Description: 20g	Part Number: 24049-2
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRST	ARTICLE IN	ISPECTION	ON CHE	CKLIST				
X First Article Prototype									
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments		
1.37	1/070		*				···		
1.27	1/030								
1.27 R.56	+/ = 30_	-							
R 10.8	+/030			-					
1.84 1.96 109°	4/030								
1.96	+/030								
1090	1/- 1/2								
- 36	+/030								
	`								
	1								
Measured by:	14	Audited by:	8/		Prototype	Approval:	N/A		
Date:	10.5.3	Date:	10/05/0	}		Date:	N/A		
Rev Date	Change					Revised by	Approved		
A Date	New Issue					KJ/JLM			

5 3 Q1Y -041 QTY -042 ITEM P/N DESCRIPTION MOUNTING LUG ASSY, LH MOUNTING LUG ASSY, RH D4049-041 D4049-042 D4049-1 LUG SHOP COPY. D4049-2 D4049-3 D4049-4 MOUNTING PLATE, LH MOUNTING PLATE, RH RETURN TO ENGINEERING UNCONTROLLED CCPY, SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 58074 Blo-4-22 D4049-041 MOUNTING LUG ASSY, LH D4049-042 MOUNTING LUG ASSY, RH 80 " WAS 83", 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2) В 10.03.19 NEW ISSUE Α RF 10.01.29 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA RF DRAWN DRAWING NO. CHECKED REV. B D4049 MFG. APPR. SHEET 1 OF 7 APPROVED TITLE SCALE **MOUNTING LUG ASSY** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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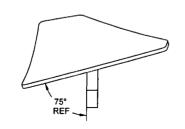
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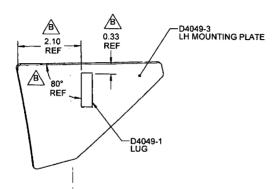
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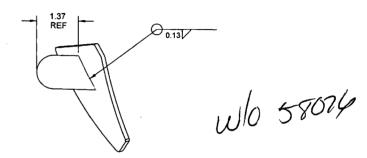
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B D4049-041 MOUNTING LUG ASSY, LH

NOTES:
1) MATERIAL: NIA
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs

7

7) WEIGHT: 0.64 lbs 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

DESIGN RF		DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	-44	DRAWING NO.	REV. B				
MFG. APPR.	- <i>P</i>	D4049	SHEET 2 OF 7				
APPROVED	-14	TITLE	SCALE				
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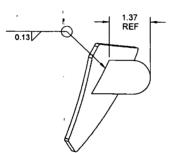
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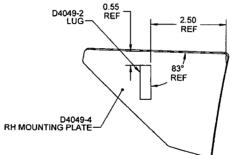
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w/o 58074

8 D4049-042 MOUNTING LUG ASSY, RH



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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs
8) WELD PER DART QSI 004 USING WELDING JIG DT9583

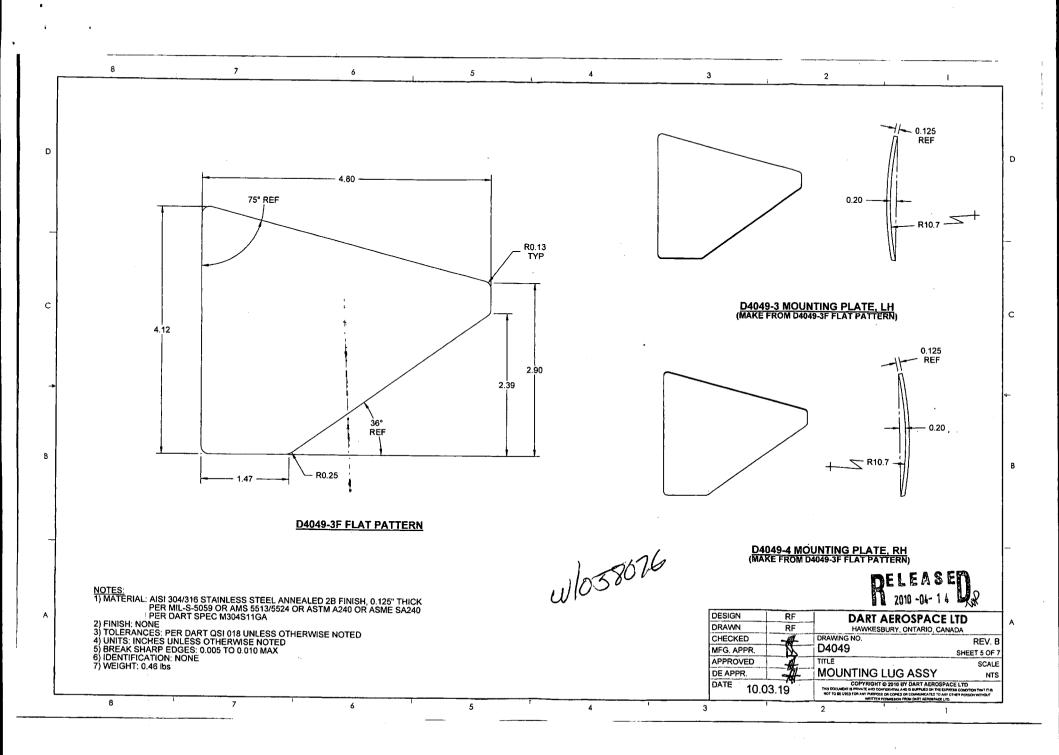
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DESIGN	RF	DART AEROSPACE LTD				
DRAWN	RF	HAWKESBURY, ONTARIO, CAN				
CHECKED	-##-	DRAWING NO.	REV. B			
MFG. APPR.	77	D4049	SHEET 3 OF 7			
APPROVED	#	TITLE	SCALE			
DE APPR.	- 74	MOUNTING LUG ASSY	NTS			
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DATE	STEP	Description of NC	Corrective Action Section B			Verifica	cation Approval		Approval	
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6 D - 1.37 -MATCH D4049-3/-4 PROFILE R0 56 R10.8 С 109° w/038076 - 0.36 REF D4049-1 LUG (SHOWN) D4049-2 LUG (OPPOSITE) NOTES:
1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.17 lbs DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4049 MFG. APPR. SHEET 4 OF 7 TITLE APPROVED SCALE DE APPR. MOUNTING LUG ASSY NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMUNICATED TO ANY OTHER PERSON DATE 10.03.19 8 7 3 2

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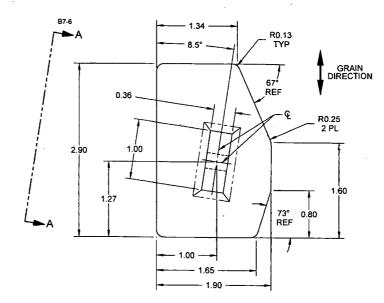


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VIEW A-A D5-6

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wl038076

D4049-5 MOUNTING LUG, LH

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs

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DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4049 MFG. APPR SHEET 6 OF 7 TITLE APPROVED SCALE **MOUNTING LUG ASSY** DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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0.13 0.50 1.00 REF R0.50 Ø0.257 R0.13 ALL AROUND

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GRAIN DIRECTION R0.13 1.00 -0.36 69 REF R0.25 2 PL 2.64 1.00 1.71 0.36 0.96 REF B7-7

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w/038074

VIEW B-B 85-7

D4049-8 MOUNTING LUG, RH

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs

7

DRAWN RF CHECKED DRAWING NO. D4049 MFG. APPR. APPROVED TITLE DE APPR.

DESIGN RF DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REV. B SHEET 7 OF 7 SCALE MOUNTING LUG ASSY NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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